

**Aero Design Ltd.****Work Order Control Sheet****Work Order#:** 2016-10 **Date Opened:** 4 Jan 16 **Title:** Assembly**Aircraft OEM:** Eurocopter **Aircraft Model:** AS350/355 **Product Type:** Cargo Basket **Product Model:** Long **Quantity:** 1**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)  
Additional Work Sheets (Standard Practice)  
Drawings (See List Below)  
Parts Distribution Sheet  
Sub Component Tags  
Completed Certification  
Time Sheet (R&D)  
Notes

Initial or N/A

JR
N/A
JR
JR
N/A
JR
N/A
N/A

**Component Completion**

Quantity Complete on This Work Order  
Quantity Incomplete on This Work Order  
Further Processing Required Before Release  
Release to Stock as Components

As Instructed

1
N/A
N/A
N/A

**Build Sheet Contents**

Tasks Initialled  
Dual Inspections Initialled

Initial or N/A

JR
JR

**Certification**

Form One Completed  
Serviceable (Green) Tag Completed  
In Process (Yellow) Tag Completed  
Unserviceable (Red) Tag Completed  
Parts Placed in Stores for Distribution

Initial or N/A

JR
N/A
N/A
N/A
N/A
N/A

**Drawing List**

Drawing #	Rev #	Description	Initial or N/A
78410	2	Basket Assembly	JR
78427	2	Placard	JR
70405	4	Lid Walkway	JR
84261	2	Handle Assembly	JR

**Additional Documentation**

Documentation of a minor change  
Non-Conformance Report Required  
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

**Billing**

Local (Aero Design)  
Research and Development  
Third Party

Initial or N/A

JR
N/A
N/A

**Traveller**

Install walkway on lid  
Install lid on basket body  
Re-tap mounting lug holes and install mount lugs  
Install handle brackets  
Install handle  
Install lid prop  
Install data plate

Initial or N/A

JR
JR
JR
JR
JR
JR
JR
JR

Work performed by:

Print: Andrew BartfaiSign: SCA: AD07Date: 13-Jan-16

ICC / Dual Inspection performed by:

Print: Jeff ClarkeSign: SCA: AD02Date: 13-Jan-16

Work Order closed by:

Print: Jason RekveSign: SCA: AD01Date: 13-Jan-16

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014



## **Aero Design Ltd.**

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity:	1	
PN:	78411-01	
Aircraft:	Eurocopter	Model: AS350/355
Description:	Long Basket Body	
Supplier:	Aero Design	
Color:	White	
WO#:	2015-132	PO# N/A



## **Aero Design Ltd.**

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: 78412-01

Aircraft: Eurocopter

Model: AS350/355

Description: Long Basket Lid

Supplier: Aero Design

Color: White

WO#: 2015-132

PO# N/A



## Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity:

1

PN:

Aluminum Checker plate

Aircraft:

All

Model: All

Description:

5 7/8" x 10', .065", pattern c102

Supplier:

Daigle Marine

Color:

N/A

WO#:

N/A

PO# 15056




## **Aero Design Ltd.**

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity: 25  
PN: MS20001P4-9600  
Aircraft: All  
Description: Hinge  
Supplier: GKN Bandy  
Color: N/A  
WO#: N/A

Model: All

PO# 15069

1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. <b>AUTHORIZED RELEASE CERTIFICATE FORM ONE</b>			3. Form Tracking No.	
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO2016-10</b>	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
	<b>Long Cargo Basket</b>	<b>78410-01</b>	<b>1</b>	<b>78401-59</b>	<b>New</b>	
12. Remarks <b>Modified with walkway on lid IAW DCL704</b>						
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12			
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation.  <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.			
13b. Signature 		13c. Approved Organization Number <b>AMF 73-04</b>		14b. Signature		14c. Approved Organization Number
13d. Name <b>Jeff Clarke - AD02</b>		13e. Date (dd/mmm/yyyy) <b>13 Jan 2016</b>		14d. Name		14e. Date (dd/mmm/yyyy)

#### Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

Pire Hawk



WO# 2016-10

Rev. Original 27 May 2013



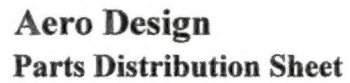
WO# \_\_\_\_\_

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013





WO# \_\_\_\_\_

Approved Manufacturing Facility 73-04

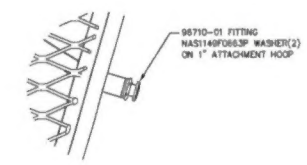
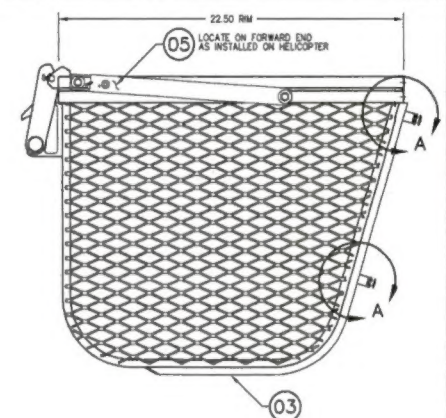
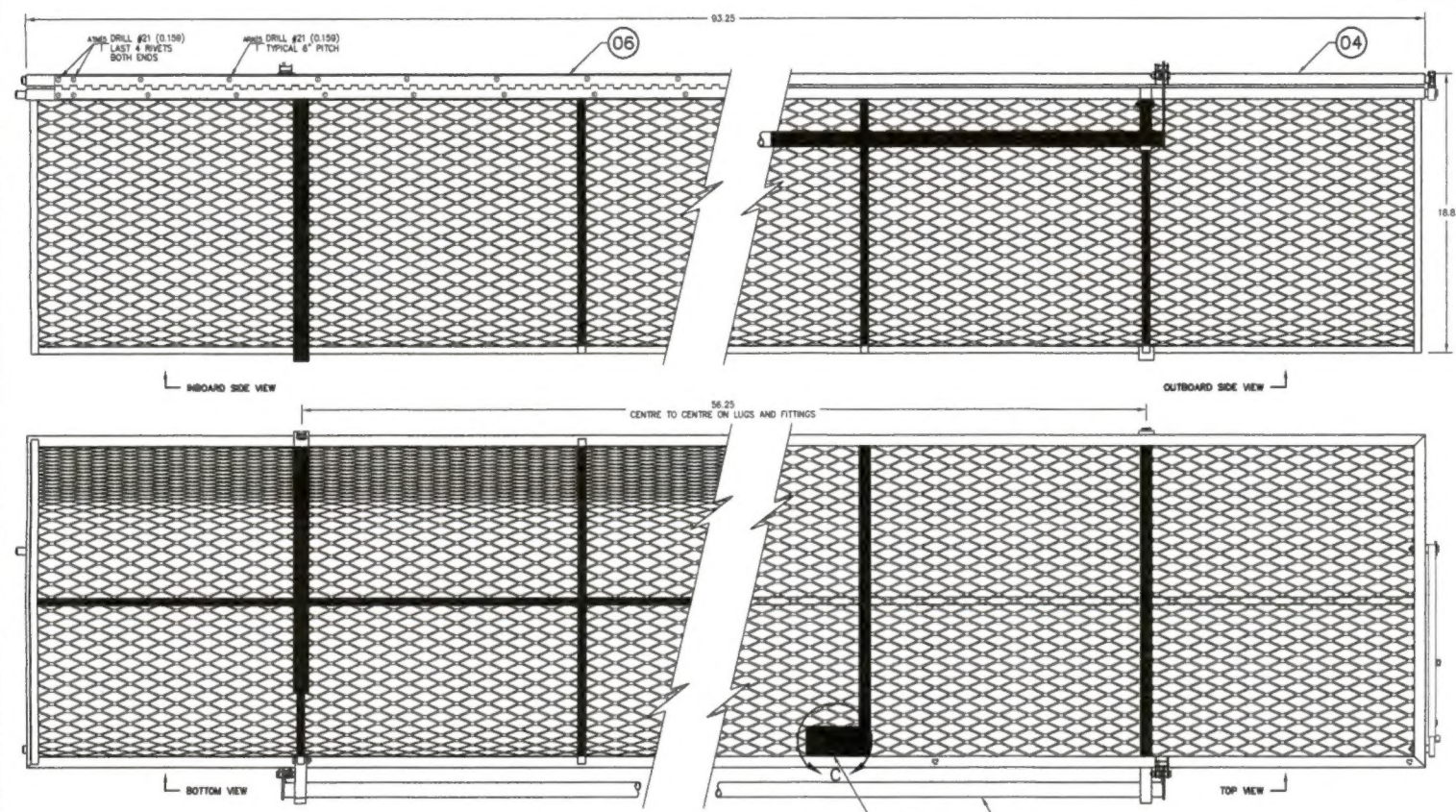
Form 20.F.06

Rev. Original 27 May 2013



2016-10

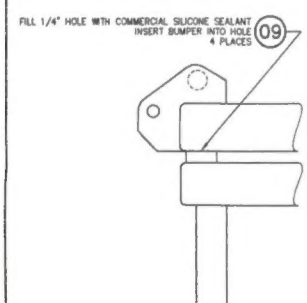
REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	CHANGED HANDLE CONFIGURATION, REMOVED ALTERNATE BASKET	BJC	27/01/2010
2	UPDATE TITLE BLOCK, ADD ALTERNATE RIVETS, HARDWARE P/N'S UPDATED, HINGE LENGTH, CHANGE BRACE ASSEMBLY TO INSTALLATION	BJC	16/07/2014



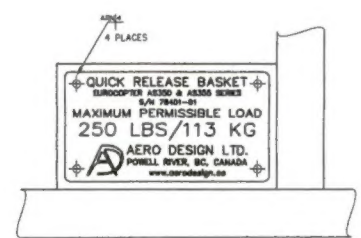
DETAIL A  
SCALE 1 : 2  
TYPICAL UPPER AND LOWER, FRONT AND REAR

NOTE:  
1. ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY. DIMENSIONS OF COMPONENTS AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS STEPS.

01 CARGO BASKET ASSEMBLY



BUMPER INSTALLATION  
SCALE 1 : 1



DETAIL C  
SCALE 1 : 1  
LOOKING AT PLACARD BRACKET

A/R	1	NAS149F0663P	WASHER			
		90710-01	FITTING	ALTERNATE: ANORA 400B8-14		
B	CR3523-5-02	CHERRY RIVET		ALTERNATE: HUCKMAX HR3523-5-02		
A/R	CR3213-5-02	CHERRY RIVET		ALTERNATE: HUCKMAX HR3213-5-02		
4	CR3213-4-02	CHERRY RIVET		ALTERNATE: HUCKMAX HR3213-4-02		
4	46205-14	09 BUMPER		ARGUS INDUSTRIES		
	78427-01	08 PLACARD				
1	84255-01	07 HANDLE BAR INSTALLATION				
A/R	MS20001P4	06 PLANO HINGE				90.0 LONG
1	84240-01	05 LID BRACE INSTALLATION				
1	78412-01	04 LID ASSEMBLY				
1	78411-01	03 BASKET BODY ASSEMBLY				
			02			
	78410-01	01 CARGO BASKET ASSEMBLY				
QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE

BASIC CODE REF. NAS 523	DASH NO. FOR DIAMETER H=MFD. HEAD NEAR SIDE F=MFD. HEAD FAR SIDE	APPROVALS DRAWN: R. RATHWELL CHECKED: E. BURGOIN	DATE 19 FEB 08
C-COUNTERSUNK D=DIMPLE DIGIT # OF SHEETS TO BE DIMPLED	DASH NO. FOR LENGTH	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1	
BASIC CODES: BJ=MS20470AD BB=MS20426AD ARN=CR3213 ATM=CR3523	+ INSTALL NEW RIVET + REMOVE/REPLACE RIVET - EXISTING RIVET		

**AERO DESIGN LTD.**  
8888A MALASPINA ROAD  
POWELL RIVER, BC, CANADA, V8A 0G3  
TEL: 804 483 8276 www.aerodesign.ca

**EUROCOPTER AS350 & AS355 SERIES  
QUICK RELEASE SKI BASKET  
BASKET ASSEMBLY (LONG)**

SCALE 1 : 4	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A1	78410	2

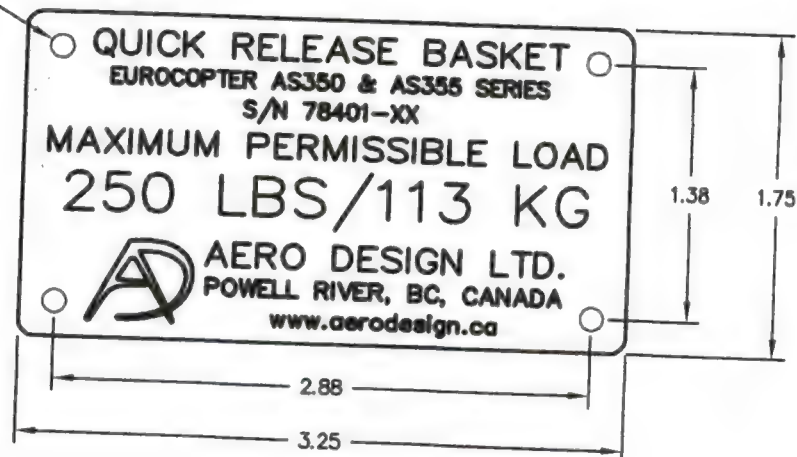


REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	INCREASE LOAD TO 250 LBS / 113 KG		
2	UPDATE TITLE BLOCK; UPDATE ADDRESS AND LOGO; MAT'L THICKNESS CHANGED	BJC	27/01/2010
		BJC	10/07/2014

#### NOTES

- ENGRAVE 0.007 DEEP AS FOLLOWS:  
 "QUICK RELEASE BASKET" - 0.125 HIGH  
 "EUROCOPTER AS350 & AS355 SERIES" - 0.080 HIGH  
 "S/N 78401-XX" - 0.080 HIGH  
 "MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH  
 "250 LBS/113 KG" - 0.200 HIGH  
 "AERO DESIGN LTD." - 0.125 HIGH  
 "POWELL RIVER, BC, CANADA" - 0.080 HIGH  
 "www.aerodesign.ca" - 0.080 HIGH


DRILL #30 (0.129)  
4 PLACES



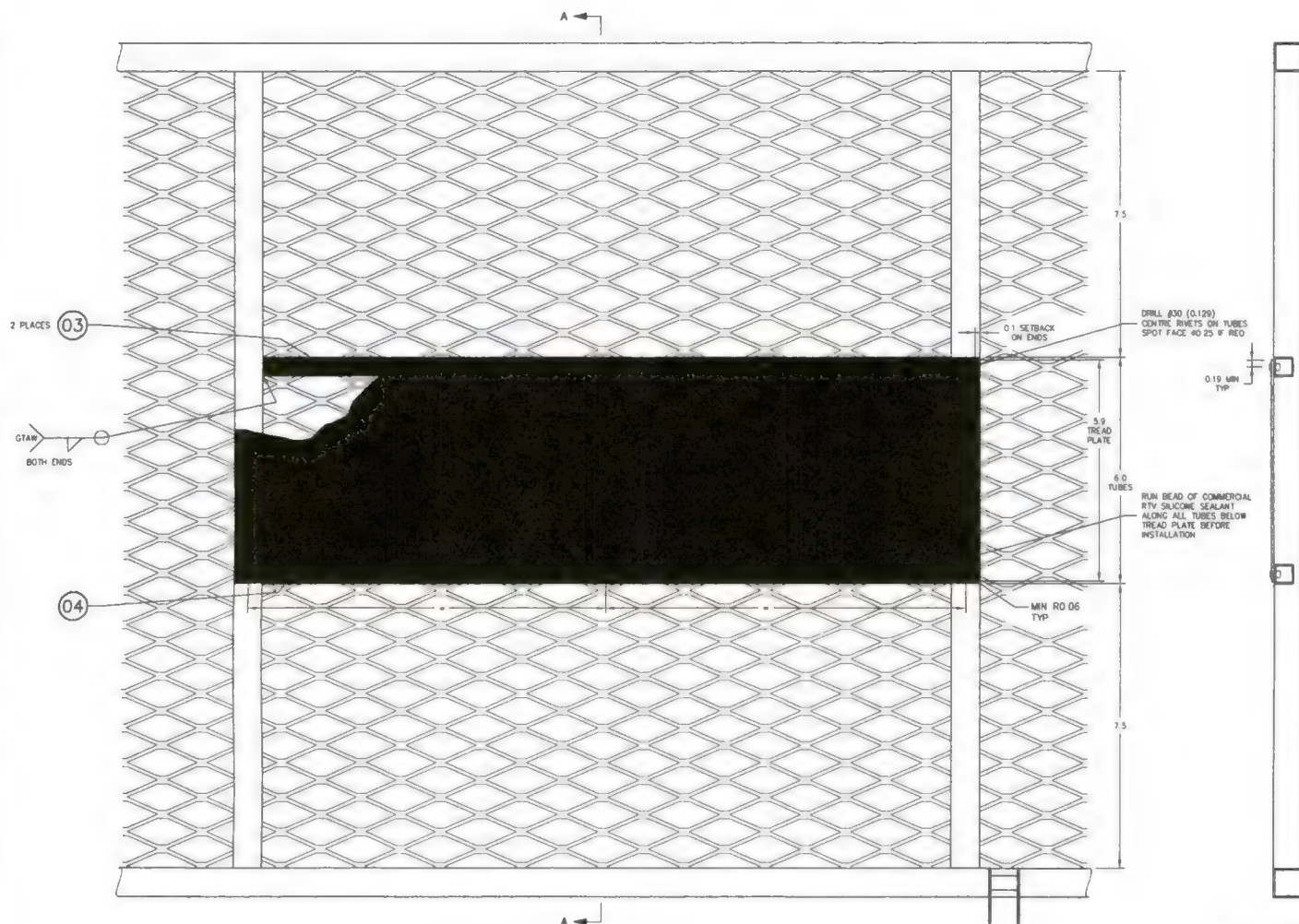
01 PLACARD

78427-01	01	PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.050 SHEET
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE

#### LIST OF MATERIALS

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.	<b>APPROVALS</b>		<b>DATE</b>		 <b>AERO DESIGN LTD.</b> 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.483.2376 www.aerodesign.ca	
	DRAWN: R. RATHWELL		18 FEB 08			
	CHECKED: E. BURGAIN					
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1				EUROCOPTER AS350 & AS355 SERIES QUICK RELEASE CARGO BASKET PLACARD	
	SCALE 1 : 1 SHEET 1 OF 1		DWG. SIZE <b>A4</b>	DWG. NO. <b>78427</b>	REV. <b>2</b>	

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
1	ADD BELL MEDIUM AND EUROCOPTER AS350 BASKETS, CHANGE TUBES	BJC	MAR 19/08
2	ADD EUROCOPTER EC135, MCDONNELL DOUGLAS MD500B, BELL 208B BASKETS	BJC	DEC 4/08
3	ADD NEW AS350 AND 208L/407 MODELS	BJC	DEC 4/08
4	TITLE BLOCK UPDATED, MODEL LIST REMOVED, ADD ALT RIVER, ADD NOTE 7	BJC	28/05/2011




## SECTION A-A

① BASKET LID ASSEMBLY

- NOTES

1. THIS DRAWING IS AN OPTIONAL CONFIGURATION ADDING A TREAD PLATE STEP TO THE LID. THIS CONFIGURATION MAY BE APPLIED TO ANY OR ALL BAYS OF THE LID. REMAINDER OF LID ASSEMBLY IS TO BE FABRICATED IN ACCORDANCE WITH THE APPLICABLE DRAWINGS
2. TUBES (ITEM 03) MUST BE WELDED IN PLACE BEFORE MESH IS WELDED ON BOTTOM
3. REMOVE ALL BURRS AND BRUISES FROM ALL SURFACES
4. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AWS D885C
5. WELDING OF 304 STEEL SHALL CONFORM TO E70TS-2 OR EQUIVALENT
6. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD
7. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLY PRIOR TO ASSEMBLY
8. TREAD PLATE PLATE AFTER COATING
9. WIDTH AND POSITION OF LID STEP MAY BE ADJUSTED TO MATCH LID DOOR INSTALLED IN ACCORDANCE WITH DRAWING 70402 ON ADJOINING BAY OF THE LID

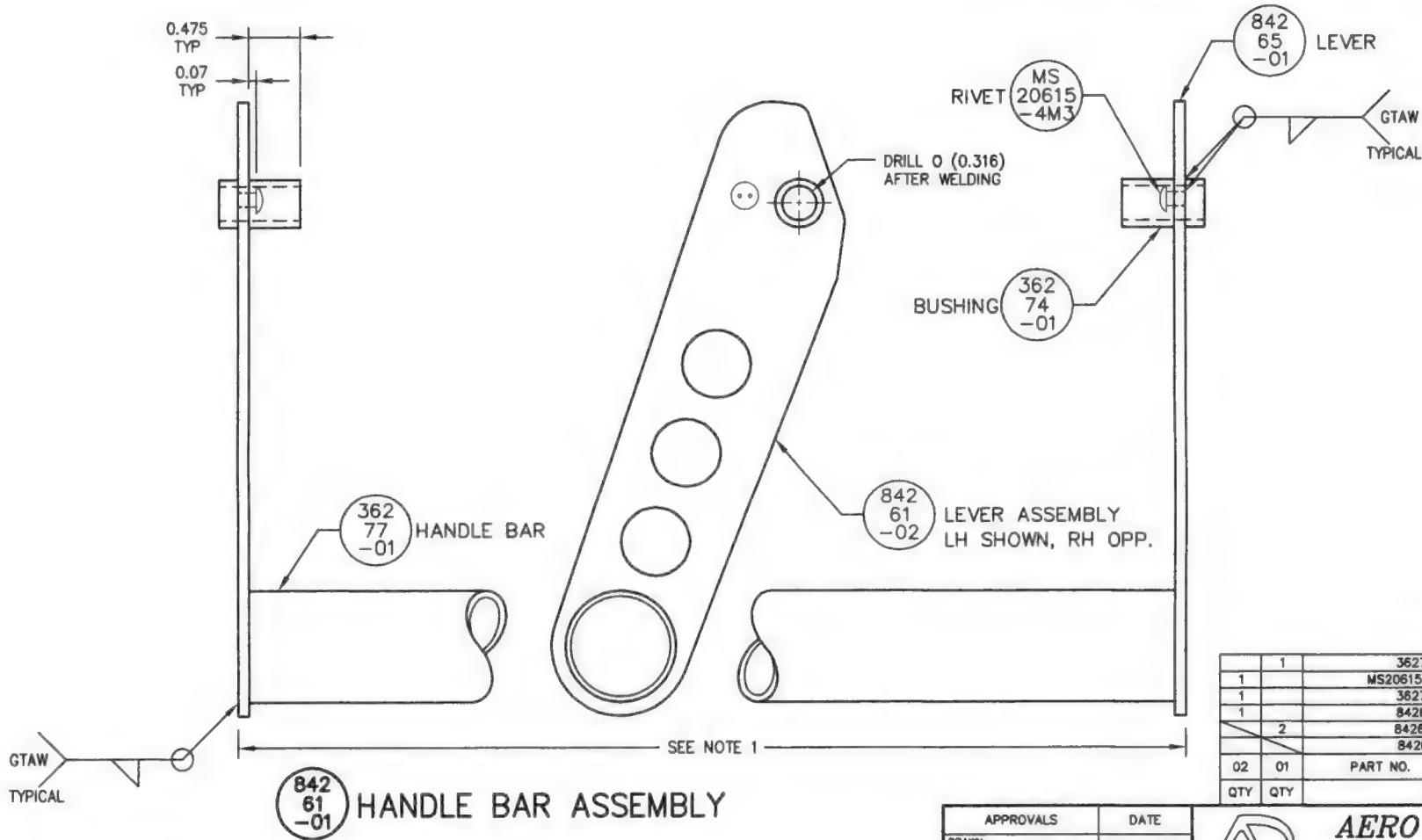
A/R	CR5213-4-02	BLIND RIVET	ALTERNATE	HR3213-4-02		
1	70405-03	04 TREAD PLATE	ALUMINUM	COMMERCIAL	0.063 TREAD PLATE	
2	70405-03	03 TUBE	4130 STEEL COND N	MIL-T-6736	0.5 X 0.035 WALL TUBE	
1	SEE NOTE 1	02 BASKET LID ASSEMBLY				
1	70405-01	01 BASKET LID ASSEMBLY - MODIFIED WITH STEP				
D1	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					

BASIC CODE REF. HAS 323		DASH NO. FOR DIMETER W=MF, HEAD NEW SIDE T=MF, HEAD FAR SIDE		APPROVALS DRAWN: JEFF CLARKIE CHECKED: E BURGIN		DATE 21 SEP 2008		 <b>AERO DESIGN LTD.</b> 6086A PARADISE ROAD POWELL RIVER, BC, CANADA, V9A 0G3 TEL: 604.484.5370    www.aerodesign.ca	
C=CONTOUR/SURF D=HOLE DIGIT# of SHEETS TO BE DIMPLED		DASH NO. FOR LENGTH		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS K.X.X ±0.010 K.X.X ±0.03 X.X ±0.1		ANGLES ±1/2°		CARGO BASKET LID SIZE MODIFICATION	
BASIC CODES: BA=MODIFIED SB=MODIFIED ARN=CR3213 ARN=CR3212		+ ⊕ INSTALL NEW RIMET + ⊕ EXISTING/REPLACE RIMET - ⊕ EXISTING RIMET						SCALE 1 : 5 SHEET 1 OF 1	



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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; LEVER ASSEMBLY ASSIGNED P/N	BJC	MAR 13/14



- NOTES:
1. LENGTH OF HANDLE TO BE DETERMINED BY BASKET ASSEMBLY DRAWING.
  2. REMOVE ALL BURRS AND SHARP EDGES.
  3. WELDING TO BE COMPLETED BY GTAW METHOD TO AMS2685C USING ER308L ROD.

QTY	QTY	PART NO.	DESCRIPTION
1		36277-01	HANDLE BAR
1		MS20615-4M3	RIVET (MONEL)
1		36274-01	BUSHING
1		84265-01	LEVER
2		84261-02	LEVER ASSEMBLY (RH/LH)
		84261-01	HANDLE BAR ASSY
LIST OF MATERIALS			

APPROVALS	DATE
DRAWN: R. RATHWELL	JUNE 18/09
CHECKED: E. BURGAIN	

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES.  
TOLERANCES ON:  
DECIMALS ANGLES  
X.XXX ±0.010 ±1/2°  
X.XX ±0.03  
X.X ±0.1

**AERO DESIGN LTD.**

9888A MALASPINA ROAD  
POWELL RIVER, BC, CANADA, V8A 0G3  
TEL: 804.468.8376 [www.aerodesign.ca](http://www.aerodesign.ca)

**HELICOPTER CARGO BASKET  
HANDLE BAR ASSEMBLY**

SCALE 1 : 1	DWG. SIZE A3	DWG. NO. 84261	REV. 2
SHEET 1 OF 1			

## CARGO BASKET HANDLE FABRICATION

### General

These instructions apply to all cargo basket handle assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

All Models: 84261, Rev. 1

Work Order: 2016-10

Complete  
(initial or SCA #)

Date Open: 13 Jan 16

1. Weld Lever Assembly – handle lever jig required  
  - a. Set MS20615-4M3 monel rivet into socket in jig
  - b. Set 36274-01 bushing into socket in jig
  - c. Set 84261-01 lever onto handle jig, with rivet and bushing protruding into lever.
  - d. TIG weld around bushing using ER308L rod.
  - e. Fuse weld rivet to lever. Additional ER308L rod may be used if required.
  - f. Repeat steps a-f using hole/socket on opposite side of jig to make opposite lever assembly.
  - g. Record material POs on attached material list.

AD-07

2. Clean up  
  - a. Clean lever assembly by media blasting with glass bead.
  - b. Drill out lever bushing to O (0.316) on lathe:
    - i. Grasp bushing in chuck, ensure rivet clears between the jaws.
    - ii. Run at 300 RPM.
    - iii. Apply a drop of Rapid-Tap to drill.
  - c. De-burr.

3. Fabricate Handle Assembly  
  - a. Temporarily install handle levers (from step 2) on lid assembly. Ensure long side of handle bushings are on INSIDE (pointing together).
  - b. Measure across TOP side of levers.
  - c. Cut handle tubing to length measured.
    - i. Handles under 40" long: 1.0" x 0.035 round tube
    - ii. Handles over 40" long: 1.0" x 0.065 round tube
  - d. De-burr tube.
  - e. Insert tube into handle levers. Tap with a plastic mallet to seat tube flush with lever. Raise handle to ensure both levers touch stops to check alignment.
  - f. Record material PO on attached material list.

AD-07

4. Weld Handle Assembly  
  - a. Fuse tube to lever on both ends. Ensure levers are parallel.

AD-05

5. Clean up  
  - a. Clean welded area with scotch-brite.

AD-07

6. Final Inspection –  
To be completed by a different person than the previous steps.
  - a. Welds for complete and handle for fit.
  - b. Tag complete and inspected parts in preparation for installation.

AD-02

## CARGO BASKET ASSEMBLY - COMMON

Complete  
(initial or SCA #)

Work Order: 2016-10

Date Open: 13 Jan 16

AD-07

### 1. Lid Assembly

- a. Install lid bumpers on bottom.
  - i. Fill bumper holes with RTV silicone sealant.
  - ii. Insert 49205-14 lid bumper, 3 or 4 places per lid.
- b. Install placard on bracket on top of lid.
  - i. Locate placard on bracket.
  - ii. Drill #30 through placard and bracket, using holes in placard.
  - iii. Remove placard and de-burr holes in placard and on bracket.
  - iv. Locate placard on bracket, and cleco in place.
  - v. Rivet placard with four CR3213-4-02 CherryMax rivets.
- c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)
  - i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
  - ii. Pull tread plate from stock. Shear tread plate to length.
  - iii. De-burr edges of tread plate with scotch-brite disc on die-grinder.
  - iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
  - v. Mark and drill #30 holes:
    1. 0.25" from edge of tread plate, centre on cross members (0.38")
    2. 0.25" from edge of tread plate, middle of each walkway stringer
  - vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using 1/4" piloted counter bore on both sides.
  - vii. De-burr holes in lid tubes.
  - viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
  - ix. Set tread plate in place, secure with clecos if necessary.
  - x. Rivet placard with CR3213-4-02 CherryMax rivets
- d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

### 2. Body Assembly

AD-07

- a. Install attachment fittings
  - i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
  - ii. Run 3/8-24 tap into attachment lugs to clear threads.
  - iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
  - iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
    1. 90610 (Robinson R44) basket only:
      - a. Install 1 fitting 906?? in lower forward attachment lug only.
      - b. Install 3 96710-01 fittings in remaining locations.
  - v. Torque to ??



- b. 946 Basket Only: Install Cutout Brace – *must be completed after hinge installation*
  - i. Locate 94621-01 Brace over aft cross tube cutout
  - ii. Install two AN4-6A bolts and two AN4-30A bolts with NAS1149F0463P washers.
  - iii. Torque AN4 bolts to ??
- c. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

## 3. Hinge Installation

AD-07

- a. Prepare hinge.
  - i. Cut hinge to length:
    - 1. 776, 906 – 54"
    - 2. 751, 803 – 70"
    - 3. 698, 764, 945 – 72"
    - 4. 784 – 90"
    - 5. 940, 946, 959 – 95"
  - ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
  - i. Locate hinge on basket (standard baskets)
    - 1. centre fore/aft
    - 2. 0.15" – 0.18" up from bottom edge
  - ii. Locate hinge on basket (extra wide baskets)
    - 1. centre fore/aft
    - 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
  - iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
  - iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
  - v. Remove hinge and de-burr holes in hinge and basket rim.
  - vi. Cleco hinge to basket with 5/32 clecos.
  - vii. Install hinge with CherryMax rivets
    - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
    - 2. CR3213-5-02 aluminum rivets – all other locations
- c. Install lid on basket
  - i. Locate lid on hinge (all baskets)
    - 1. center fore/aft
    - 2. 0.15" – 0.18" down from top edge
  - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
  - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
  - iv. Remove hinge and de-burr holes in hinge and lid rim.
  - v. Cleco lid to hinge with 5/32 clecos.
  - vi. Install hinge with CherryMax rivets
    - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
    - 2. CR3213-5-02 aluminum rivets – all other locations



- d. Record PO of hinge and rivets on attached material tracking list.

4. Install Handle

AD-07

a. Install handle brackets.

- i. Set 84267-01 handle bracket on provisions in hoops, 2 places.
- ii. Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
- iii. Torque AN3 bolts to ??.

b. Install handle

- i. Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
- ii. Grease two 36275-01 bushings with ??. Insert into bushings of handle assembly.
- iii. Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
- iv. On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
- v. At first end, remove bolt and repeat step iv.
- vi. Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
- vii. Torque AN3 bolts to ??.

c. Check handle

- i. Operate handle to ensure handle does not bind and springs hold handle in.
- ii. Snap handle into brackets to ensure handle locks.

- d. Record PO/WO of all parts used in steps above on attached material tracking list.

5. Install lid brace

AD-07

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to ??
- f. Record PO/WO of all parts used in steps above on attached material tracking list.

## CARGO BASKET ASSEMBLY - COMMON

Complete  
(initial or SCA #)

AD02

### 6. Final Inspection

Dual inspection by a different person than assembled the basket.

- a. Check for general condition and correct assembly:
  - i. Bolts are tight
  - ii. Rivets are installed correctly
  - iii. Handle operates correctly
  - iv. Lid brace operates correctly
- b. Check that PO/WO numbers have been recorded.